

Work Order ID 51103

August 4, 2009 11:03:30 AM

Page 1

Item ID: D2617-3

Revision ID: D2

Item Name: Bushing

Start Date: 8/31/09 Start Qty: 40.00

Required Date: 8/31/09 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: mf Date: 09-08-04

QC: Date: _____

Tooling:

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2617	Rev D2								

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Turn as per Folio FA437 and Dwg D2617

0.00

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

ASAP



Cust Item ID:

Customer:



SA 09/08/06

40

SA 09/08/06

40

DT 09/08/07

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51103

August 4, 2009 11:03:30 AM

Page 2

Item ID: D2617-3

Accept

Revision ID: D2

Item Name: Bushing

Start Date: 8/31/09 Start Qty: 40.00

Required Date: 8/31/09 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr break all unmarked sharp edges 0.005 to 0.010

SA 09/08/06

140

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

DL 09-08-7.

40

150

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

AP 09-08-09

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51103



Page 3

August 4, 2009 11:03:30 AM

Item ID: D2617-3

Accept



Setup Start



Revision ID: D2

Stop



Item Name: Bushing

Start Date: 8/31/09 Start Qty: 40.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>39</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/8/11 54 400

09-08-11

ME 09-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

August 4, 2009 11:03:29 AM

Work Order ID: 51103

Parent Item: D2617-3RevD2

Parent Item Name: Bushing


Comments:

Start Date: 8/31/09

Required Date: 8/31/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	169.6200	3.0695			
												
6061-T6 RD Tube .375 x.058W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	169.62	
110485	9.67	
110968	3.67	
111432	36.28	
111944	120	

MF 09-08-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

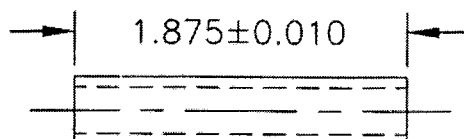
NOTE: Date & initial all entries



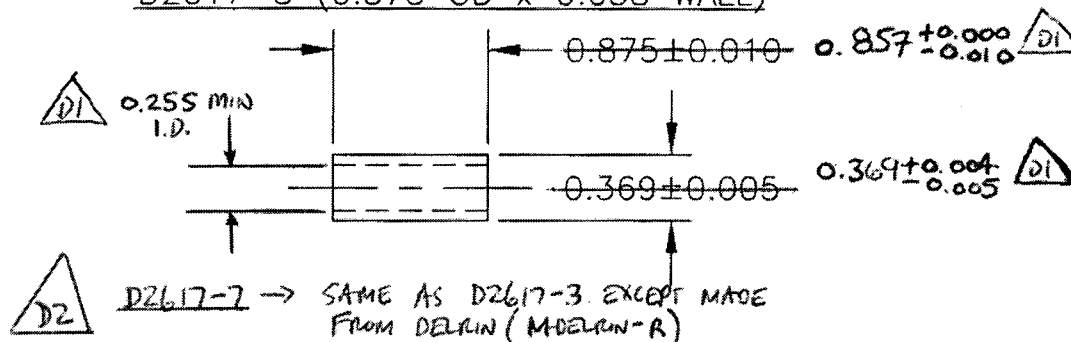
DESIGN BW		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #		APPROVED #		DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING	SCALE 1:1
A	96.10.08		NEW ISSUE		
B	97.05.08		.875 WAS 1.125		
C	97.06.04		0.369 DIA WAS 0.375		
D	01.07.04		ADD MAT'L SPEC AND TOL./DIM. NOTE		
DI	CP-#	04.07.12	CORRECT TOLERANCE (NCR 779)		

51103
mf
09-08-04

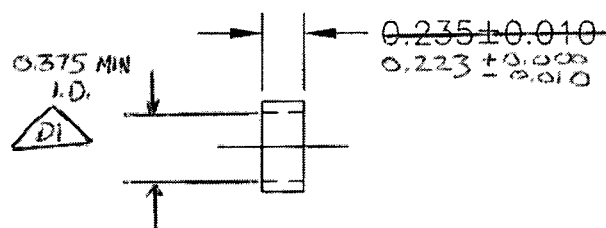
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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